

Date: Friday, 14/07/2006 2:46:00 PM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	CABLE GUARD
Job Number	27906		
Estimate Number	12458		
P.O. Number	11A	Part Number	D29165
This Issue	14/07/2006	S.O. No.	N/A
Prsh Rev.	NC	Drawing Number	D2916 REV B
First Issue	13/07/2006	Project Number	N/A
Previous Run		Drawing Revision	B
Written By	<u>See comment Below</u>	Material	N/A
Checked & Approved By		Due Date	10/08/2006
Comment	Est Rev:A New Issue 06-06-19 JLM	Qty:	10
Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	WATER JET	FLOW WATER JET	
 Comment: FLOW WATER JET			
2.0	MUHMWB10	UHMW 1" Black	
 Comment: Qty.: 0.4000 sf(s)/Unit Total: 4.0000 sf(s)			
UHMW 1" Black <u>Batch # 101253</u> <u>SAN 06:08:10</u> <u>10</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
 Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SAN 06:08:10</u> <u>10</u>			
4.0	QC8	SECOND CHECK	
 Comment: SECOND CHECK <u>TMF 06/08/15</u> <u>10</u>			
5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
 Comment: HAAS CNC VERTICAL MACHINING #1			
<u>BATCH: 101253</u>			
<u>1- Mill as per Folio FA2916-5 Rev: A & Dwg D2916 Rev: B</u>			
<u>2-Deburr per dwg D2916</u>			
<u>TMF 06/08/15</u> <u>10</u>			

Date: Thursday, 7/13/2006 3:38:18 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CABLE GUARD		
Job Number	: 27906		Part Number	: D29165		
Estimate Number	: 12458		Drawing Number	: D2916 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 7/13/2006	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : MACHINED PARTS	Due Date	: 8/10/2006		Qty: 10 Um: Each
Previous Run	:					
Written By	:					
Checked & Approved By	:					
Comment	: Est Rev:A New Issue 06-06-19 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		 Comment: PURCHASING Issue P/O: _____ For (1) D2916-5 32.23" x 1.75" x 1.00" (_____ Tolerance for all measurements is (+0.030/-0.000) Material: Black UHMW(MUHMWB10) Possible Supplier: GE PolymersMaterial release note is required
		 <i>cut on waterjet</i> <i>MUHMWB10</i>
2.0	PACKAGING 1	 Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached
3.0		
4.0	HAAS1	 Comment: DIMENSIONAL CHECK

Comment: HAAS CNC VERTICAL MACHINING #1

BATCH: _____

1- Mill as per Folio FA2916-5 Rev: _____ & Dwg D2916 Rev: _____

2-Deburr per dwg D2916

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/13/2006 3:38:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 27906

Part Number: D29165

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
6.0	QC8	SECOND CHECK
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
7.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		
8.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Inspection Level 21		

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

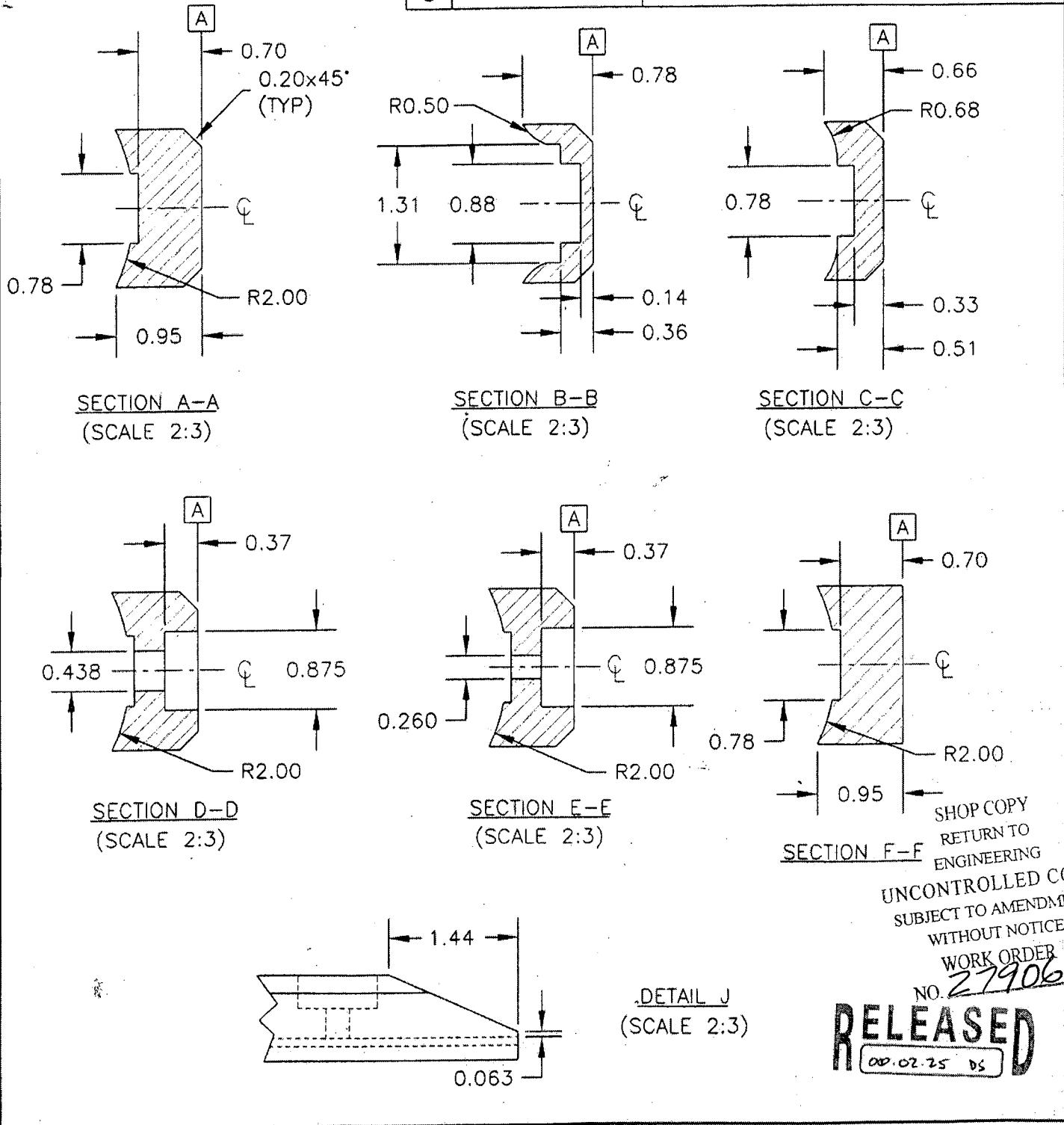
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

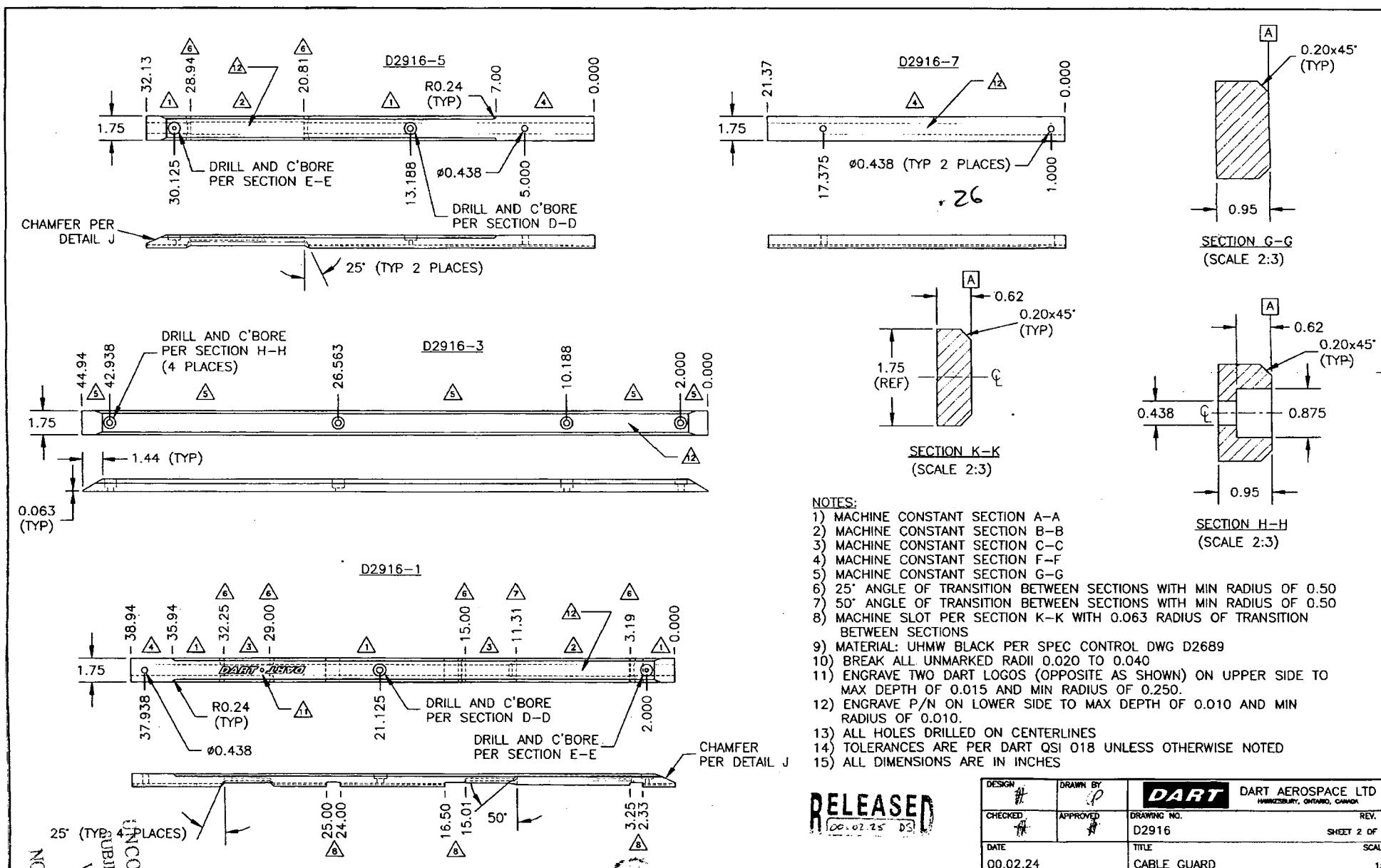
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DARTCOPY ISSUE
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2916	SHEET 1 OF 2
DATE		TITLE	SCALE
00.02.24		CABLE GUARD	1:6
A	99.09.29	NEW ISSUE	
B	00.02.24	ADD K-K FOR D2521 COMPATIBILITY	





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWTHORPE, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2916
DATE 00.02.24		SHEET 2 OF 2 TITLE CABLE GUARD SCALE 1:6

NO
WORK
ORDER
SUBJECT TO AMENDMENT
WITHIN NOTICE
COPY
RETURN TO
ENGINEERING
CABLE GUARD

DART AEROSPACE LTD	Work Order:	27906
Description:	Part Number:	D29165
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.75	± 0.030	1.749	✓		Vern	
32.13	± 0.030	32.125	✓		Measuring tape Vern	
1.00	$\pm 0.00 \pm 0.030$	1.020	✓		Vern	
.140"	$\pm .030"$.130"	✓			
.360"	$\pm .030"$.355"	✓			
.780"	$\pm .030"$.782	✓			
.700"	$\pm .030"$.699"	✓			
.950"	$\pm .030"$.943"	✓			
.780"	$\pm .030"$.810"	✓			
.20 x 45°	$\pm .030"$.200"	✓			
1.310"	$\pm .030"$	1.290"	✓			
.88	$\pm .030"$.871"	✓			
.370"	$\pm .030"$.374"	✓			
.875"	$\pm .010"$.874"	✓			
Ø .438"	$\pm .006"$	Ø .437"	✓			
Ø .260"	$\pm .006"$	Ø .259"	✓			
1.44"	$\pm .030"$	1.44"	✓			
.063"	$\pm .010"$.073"	✓			
5.000"	$\pm .010"$	5.007"	✓			

Measured by: <u>JAD</u>	Audited by: <u>J.G</u>	Prototype Approval: <u>N/A</u>
Date: <u>06/08/10</u>	Date: <u>06/08/10</u>	Date: <u></u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	